

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002825**Date Inspected:** 01-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Jiang Jian Fei	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes No N/A	
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes No N/A	
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes No N/A	
Approved Drawings:	Yes No N/A	Approved WPS:	Yes No N/A	
		Delayed / Cancelled:	Yes No N/A	
Bridge No:	34-0006	Component:	Tower	

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector, Ken Jobes, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, to randomly monitor welding and Quality Control (QC) functions. While on site, the QA Inspector observed and/or discovered the following:

New Tower Bay 1

The Caltrans QA Inspector randomly observed the machine Submerged Arc Welding (SAW) of fill passes on Weld No. SSD1-SA40A/E-18B. The welding operator was Yun Chuan jin (I. D. No. 0503060). The welding was in the flat groove (1G) position using Welding Procedure Specification (WPS) No. WPS-B-T-2221-B-U3c-S. Certified Welding Inspector (CWI), Jiang Jian Fei (CWI No. 07120691) was present during this welding as was ABF QA Inspector, Kong Yian hui. The QA Inspector verified the electrode as JW-3 (EM12K) and the diameter of the electrode as 4.0 mm. The minimum preheat and maximum interpass temperatures, voltage, amperage and travel speed were all verified as being within the parameters of the WPS.

New Tower Bay 2

The Caltrans QA Inspector also randomly observed the machine Submerged Arc Welding (SAW) of the root pass and second pass on Weld No. ESD1-SA237 A/F-23A. The welding operator was Cao Xiao Hua (I. D. No. 056975). The welding was in the flat groove (1G) position using Welding Procedure Specification (WPS) No. WPS-B-T-2221-B-U3c-S-1. Certified Welding Inspector (CWI), Jiang Jian Fei (CWI No. 07120691) was present during this welding as was ABF QA Inspector, Yang Yi feng. The QA Inspector verified the qualifications of the

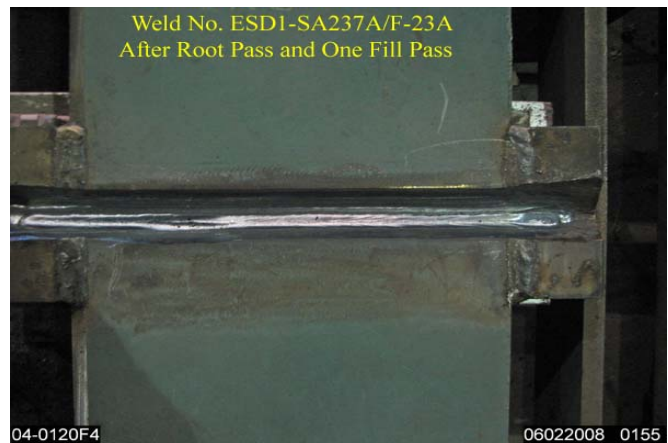
WELDING INSPECTION REPORT

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welding operator, the electrode as JW-3 (EM12K) and the diameter of the electrode as 4.0 mm. The minimum preheat and maximum interpass temperatures, voltage, amperage and travel speed were all verified as being within the parameters of the WPS. Later in the shift, the QA Inspector observed the above personnel, ie. welding operator, CWI and ABF Inspector, using machine SAW to weld fill passes on Weld No. ESD1-SA107E/J-22B. WPS-B-T-2221-B-U3c-S was being used.

The Caltrans QA Inspector also randomly observed the machine Submerged Arc Welding (SAW) of the root pass and second pass on Weld No. ESD1-SA216A/K-14A. The welding operator was Sun Bing fa (I. D. No. 062046). The welding was in the flat groove (1G) position using Welding Procedure Specification (WPS) No. WPS-B-T-2221-B-U3c-S-1. Certified Welding Inspector (CWI), Jiang Jian Fei (CWI No. 07120691) was present during this welding as was ABF QA Inspector, Yang Yi feng. The QA Inspector verified the qualifications of the welding operator, the electrode as JW-3 (EM12K) and the diameter of the electrode as 4.0 mm. The minimum preheat and maximum interpass temperatures, voltage, amperage and travel speed were all verified as being within the parameters of the WPS.

All above observations appeared to meet the requirements of the job specifications.



Summary of Conversations:

As identified within the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Jobes, Kenneth

Quality Assurance Inspector

Reviewed By: Cochran, Jim

QA Reviewer